

# Work Order ID 51373

August 20, 2009 1:33:24 PM



Page 1

Item ID: D2037-101

Accept



Setup Start



Revision ID: D

Stop



Item Name: Arm

Start Date: 08/20/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 08/24/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan: MMF

Date: 09-08-20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
----------	--------------	--	--	--	--	--	--	--	--

100		0.00							
	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	Punch as per Dwg D2037. Keep hole distance 45.50" using Jig D2037-101T1								

5 0

SB 09/08/21

110		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Drill Ø0.323" holes in D2037-101 tube as per Dwg D2037 ends of D2037-101 tube as required using DT8545 3-Deburr as required								

2-Flatten

M-h 09/08/24 (5X)

120		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

=> 5 09/09/24

(45) 0

**Work Order ID 51373**

August 20, 2009 1:33:24 PM



Page 2

Item ID: D2037-101

Accept



Setup Start



Revision ID: D

Stop



Item Name: Arm

Start Date: 08/20/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 08/24/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Packaging

Memo

Packaging

Identify as per dwg & Stock Location: *MISC*

0.00

0.00

*CP 09-08-24**5*

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

*09/08/26**u 9.8.24*

# Picklist Print

Page 1

August 20, 2009 1:33:23 PM

Work Order ID: 51373



Parent Item: D2037-101RevD



Parent Item Name: Arm

Start Date: 08/20/2009

Required Date: 08/24/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			110	f	319.5510	20.6105			

304 RD Tube .750 x .049W

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

MAT

319.5510026

107518

7.27

108498

0

109314

8.5

110113

0.73

110271

0.03

111096

9

111457

11.43

111619

13.2700026

112187

269.321

22

SB 09/08/21

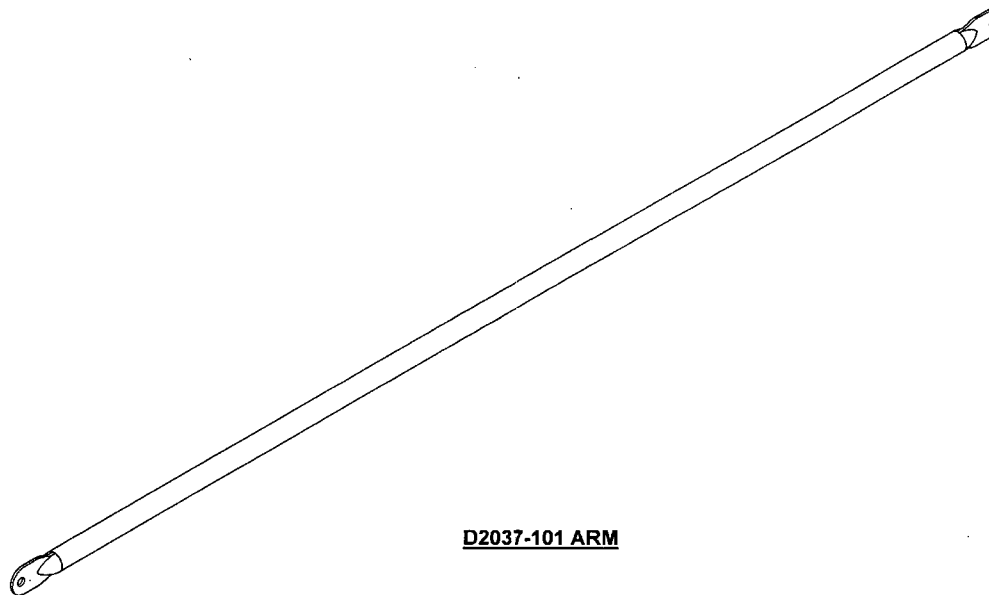
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D2037-101 ARM**

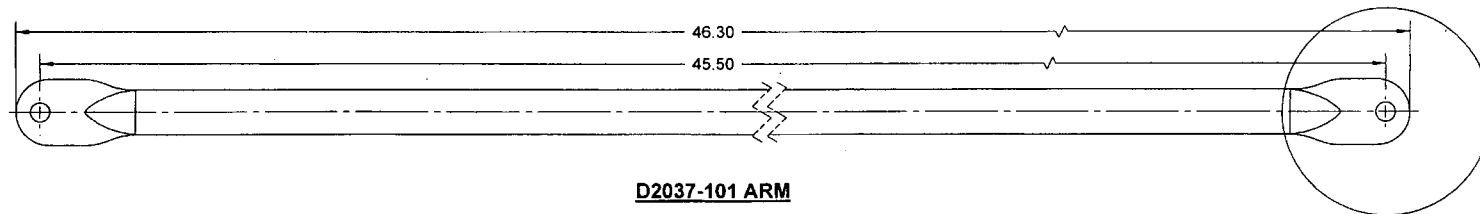
*#57373  
MFG  
09-08-70*

**RELEASED**  
08.07.12

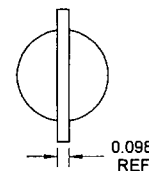
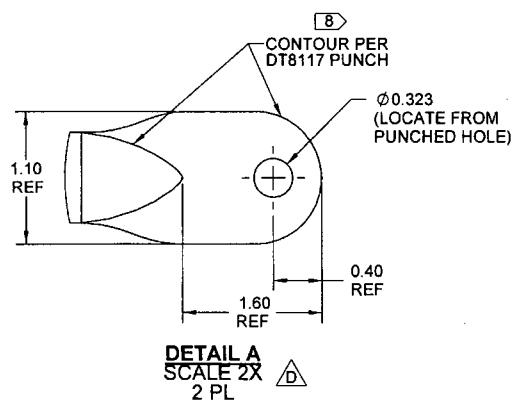
**NOTES:**

- 1) MATERIAL: AISI 304/316, STAINLESS STEEL ROUND TUBE,  $\phi 0.750 \times 0.049$  WALL  
REF. DART SPEC M304TR0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.50 lbs
- 8) FOR FURTHER INFO SEE DRAWING D2638.

D	INCORPORATED C1, C2 & C3. REDRAWN TO SOLIDWORKS FORMAT WITH CURRENT STANDARDS. ORIGINAL "SQUARE END" CONFIGURATION DELETED (SEE REV. C FOR FURTHER DETAILS). SHEET 2 DETAIL A NOW INDICATED AS 2 PL. REASON FOR CHANGE: QC/PRODUCTION REQUEST.	AJS	08.05.08
C	REDRAWN, 0.386 WAS 0.375.	RF	99.06.07
B	-103 DELETED	JB	93.04.20
A	NEW ISSUE	JB	91.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2037	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ARM	NTS
DATE	08.05.08	COPYRIGHT © 1991 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



**D2037-101 ARM**



51373

RELEASED  
06-07-07

DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		<b>D2037</b>	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>ARM</b>	NTS
DATE	08.05.08	<small>COPYRIGHT © 1991 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	